
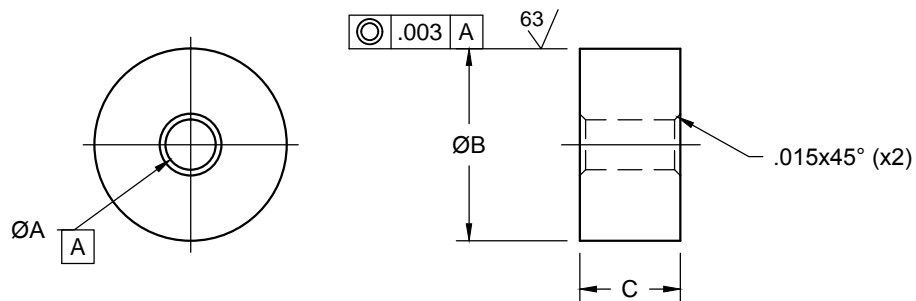
 RED BARN MACHINE	
TITLE KSTS302T001-### SERIES DP TRI-ROLLER SWAGING TOOLS; LOCATING PIN	
DWG NO. T00L# (see chart)-15	REV -
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR. 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 11-29-08
SHEET 9 of 9	

[illegible]

NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).

 RED BARN MACHINE	
TITLE KSTS302T001-### SERIES DP TRI-ROLLER SWAGING TOOLS; PIN	
DWG NO. T00L# (see chart)-9	REV -
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR. 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 11-28-08 SHEET 6 of 9



-7

GUIDE


UNDER REVIEW

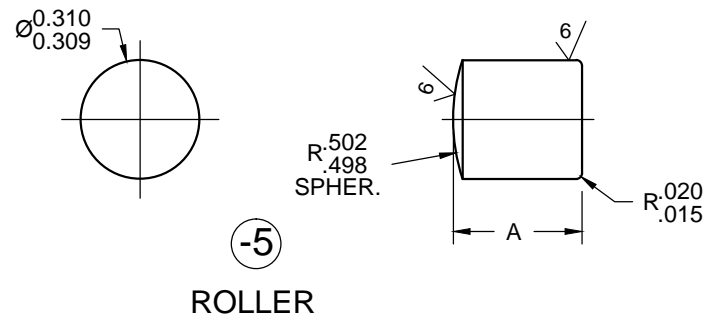
URF 19-1117 19.10.30 (VM)

NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).


TOOL #	ØA +.001 -.001	ØB +.000 -.002	C +.000 -.010	MATERIAL
KSTS302T001-200	.131	.998	.281	BRONZE RND. BAR Ø1-1/8 x 3/8
KSTS302T001-206	.131	.310	.160	BRONZE RND. BAR Ø3/8 x 3/8
KSTS302T001-805	.131	.248	.170	BRONZE RND. BAR Ø3/8 x 3/8

 RED BARN MACHINE			
TITLE KSTS302T001-### SERIES DP TRI-ROLLER SWAGING TOOLS; GUIDE			
DWG NO. TOOL# (see chart)-7			REV —
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1		DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC USED ON BEARING	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		SEE Pg. 1	
SCALE NTS	DATE 11-24-08	SHEET 5 of 9	

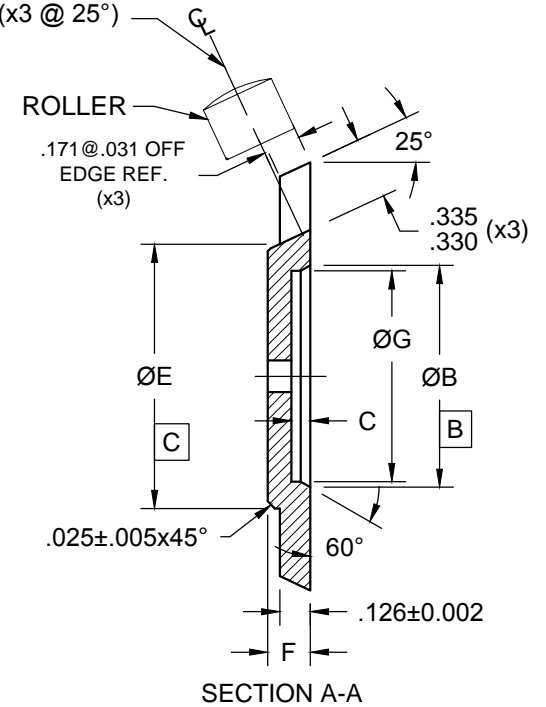


UNDER REVIEW
URF 19-1117 19.10.30 (VM)

TOOL #	A +.001 -.001	MATERIAL			
KSTS302T001-200	.335	.310 MINUS	GAUGE PIN	MSC#89031009	
KSTS302T001-206	.335	.310 MINUS	GAUGE PIN	MSC#89031009	
KSTS302T001-805	.335	.310 MINUS	GAUGE PIN	MSC#89031009	

 RED BARN MACHINE			
TITLE KSTS302T001-### SERIES DP TRI-ROLLER SWAGING TOOLS; ROLLER (x3)			
DWG NO. TOOL# (see chart)-5		REV -	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT	
TOLERANCES ON:		APPROVED	
DECIMALS		HEAT	
.XXX ± .005		TREAT	
.XX ± .01		FINISH	
X ± .1		SPEC	
FRACTIONS ± 1/32		USED ON BEARING	
ANGLES ± 5°		SEE Pg. 1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE NTS	DATE 11-24-08	SHEET 4 of 9	

Ø5/16 END MILL
(x3 @ 25°)



SECTION A-A

1. BREAK ALL SHARP CORNERS (.015/.03).

 RED BARN MACHINE

DWG NO. TOOL# (see chart)-3

SEE Pg. 1

SCALE	NTG
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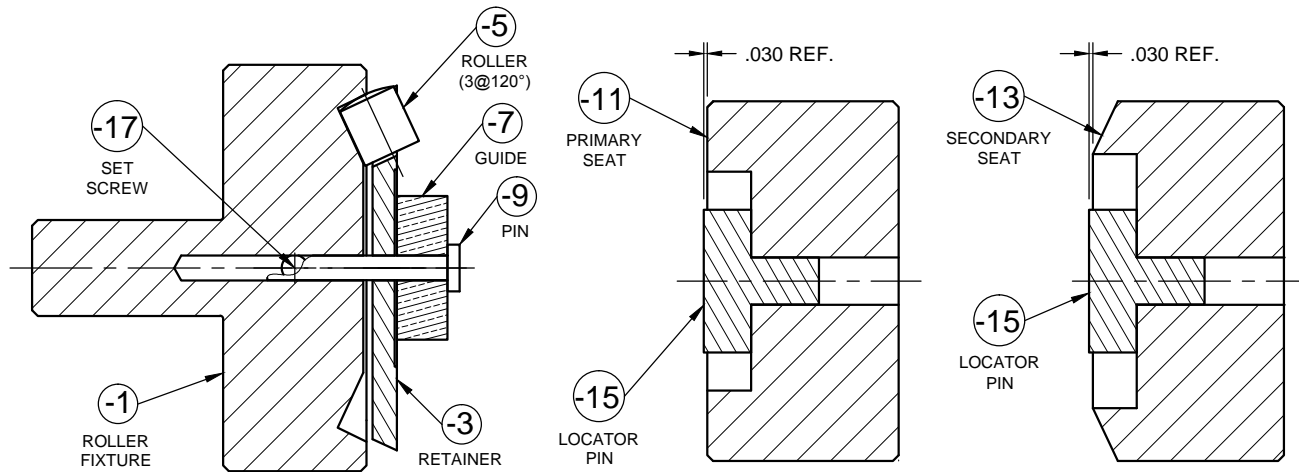
SCALE NIS

DATE 11-24-08

SHEET 3 of 9

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
-	-	-	-	-



UNDER REVIEW
URF 19-1117 19.10.30 (VM)

NOTES

1. -5 ROLLERS MUST TURN FREELY IN -3 RETAINER POCKETS.
2. -5 ROLLERS & -3 RETAINER MUST TURN FREELY WHEN TOOL IS COMPLETELY ASSEMBLED.
3. FLAT END OF ROLLERS MUST FACE TOWARDS THE CENTER OF THE TOOL WHEN ASSEMBLED.

BEARINGS & TOOLS COVERED		
BEARING #	BEARING #	TOOL #
S302T001-200	MS14101-16	KSTS302T001-200
S302T001-206	BABC10FB05	KSTS302T001-206
S302T001-805	MS14103-4	KSTS302T001-805

RED BARN MACHINE

ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	B/O INFORMATION OR SPECIFICATIONS	Pg.	TITLE		
		-1	1	ROLLER FIXTURE	SEE CHART	2	KSTS302T001-### SERIES DP		
		-3	1	RETAINER	SEE CHART	3	TRI-ROLLER SWAGING TOOLS		
		-5	3	ROLLER	SEE CHART	4	DWG NO. TOOL# (see chart above); ASSEMBLY		
		-7	1	GUIDE	SEE CHART	5	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
		-9	1	PIN	SEE CHART	6	TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1		
		-11	1	PRIMARY SEAT	SEE CHART	7	UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		
		-13	SEE CHART	SECONDARY SEAT	SEE CHART	8	DRAWN BY: PERRITT		
		-15	SEE CHART	LOCATING PIN	SEE CHART	9	APPROVED		
	B/O	-17	1	SOCKET HEAD SET SCREW	#8-32 x 1/4	N/S	HEAT TREAT LISTED PER ITEM FINISH LISTED PER ITEM USED ON BEARING SEE ABOVE		
SCALE NTS							DATE	11-24-08	SHEET 1 of 9


[illegible]

NOT APPROVED FOR PRODUCTION

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

UNDER REVIEW
URF 19-1117 19.10.30 (VM)

	PART #	QTY	DESCRIPTION
	-1	1	--

DRAWN BY: PERRITT	 RED BARN MACHINE		
CHECKED			
HEAT TREAT FINISH SPEC			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± .5° .X ± .1			
USED ON MODEL ?	TITLE	TITLE	
	DWG NO.	PART #	REV.
	SCALE NTS	DATE 1-28-06	SHEET 1 of 1
	UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		

TEST SUBJECT
NOT APPROVED FOR PRODUCTION

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

UNDER REVIEW
URF 19-1117 19.10.30 (VM)

NOTES

- 1. ENGRAVE P/N; CHARACTER HT. .090.
- 2. ENGRAVE 'PRIMARY'
- 3. ENGRAVE 'SECONDARY'

RT #	QTY	DESCRIPTION
-1	1	0-1 DRILL ROD Ø2-1/8 x 1-7/8
-3	1	BRASS RND Ø2 x 5/16
-5	3	0-1 DRILL ROD Ø3/8 x 1/2
-7	1	BRASS RND Ø3/4 x 3/8
9	1	1018 RND Ø1/4 x 1-1/8
11	1	1018 RND Ø1-7/8 x 1-1/8
13	1	1018 RND Ø1-7/8 x 1-1/8
15	1	1018 RND Ø3/4 x 3/4

USED ON MODEL
?

DRAWN BY:	PERRITT
APPROVED	
HEAT TREAT	
FINISH SPEC	BLACK OXIDE
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	
.XXX ± .005	FRACTIONS ± 1/32
.XX ± .01	ANGLES ±.5°
.X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES Ø15 x 45° PP Ø15 P	

RB RED BARN MACHINE	
TITLE STAKING TOOLS	
DWG NO. RB ST1016	REV
SCALE	DATE 1 24 07 SHEET 1 OF 1